

74803

October 6, 2011 1:42:02 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 10/06/11 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 10/17/11 **Req'd Qty:** 4.00 ***A***

Customer:

Reference:

*Run Start *NR1*

Approvals: Process Plan: M.C.J Date: 11/10/06 Tooling:

Date:

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74803

74803

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Item ID: D3560-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm Weldment
 Start Date: 10/06/11 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 10/17/11 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00				4	0		
Quality Control									
140		0.00							
140									
Large Fab	Large Fab	0.00				4	0		
Large Fab	Memo								
	1-Weld assembly as per dwg D3560								
	STEP:								
	1- clean material (buff bracket and bottom of arm with blue pad)								
	2- set up bracket and arm on jig								
	3- preheat bracket and arm with torch								
	4- clean before welding with brush								
	5- set up machine to 135 amps								
	6- weld across bottom and top ends								
	7- reheat with torch (65 deg C)								
	8- on one side weld from bottom to top half way								
	9- same for other side (half way)								
	10- from half way point weld the rest of the first side (ease off pedal near end)								
	11- same for remaining side (ease off pedal near end)								

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Item ID: D3560-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm Weldment

Start Date: 10/06/11 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>✓</u>	<u>0</u>	<u>BE11-11-17</u>	
160 *160* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<u>4</u>	<u>0</u>	<u>BE11-11-17</u>	
170 *170* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>4X</u>	<u>0</u>	<u>11/11/17</u>	

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									
190		0.00							
190	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Press bushing in D3560 arm per dwg D3562								
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									

11.11.17 (4)

9/30/11/18 (4)

8 11/11/18

(*)
2011

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 Reference:

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <i>inst</i>	0.00				4	0		
210									
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL ***								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

11/11/21 *11-11-18*
(4)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

October 6, 2011 1:42:06 PM

Page 1

Work Order ID: 74803

74803

Parent Item: D3560-041

D3560-041

Parent Item Name: Arm Weldment

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2808 *D2808* Bushing		Manufactured	No			100	Each	18.0000	1	4			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		18							
				32896		2							
				71879		16							
M6061T6B0.500X05.00 0		Purchased	No			140	f	14.4750	1.395	5.873684			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT004		14.475							
				112154		6.935							
				117933		7.54							
D3592-1 *D3592-1* Plate		Manufactured	No			190	Each	17.0000	1	4			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA002		17							
				47015		2							
				48517		15							

Handwritten signature: *ES 11/11/18*

Handwritten signature: *FK 11/11/09*

Handwritten signature: *11.11.16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74803
Description: Arm		Part Number: D3560-1
Inspection Dwg: D3560	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5062	/		mic .5L4	
Ø0.196	+0.005/-0.001	.196	/		vern .5L3	
Ø1.000	+0.010/-0.001	1.003	/		"	
0.500	+/-0.010	.495	/		"	
0.250	+/-0.010	.251	/		"	
0.275	+/-0.010	.274	/		"	
0.188	+/-0.010	.183	/		"	
2.000	+/-0.010	2.000	/		"	
1.700	+/-0.010	1.700	/		"	
Ø0.385 x 100°	+/-0.010 x 0.5°	.385x100°	/		"	
0.250 Deep	+/-0.010	.252	/		"	

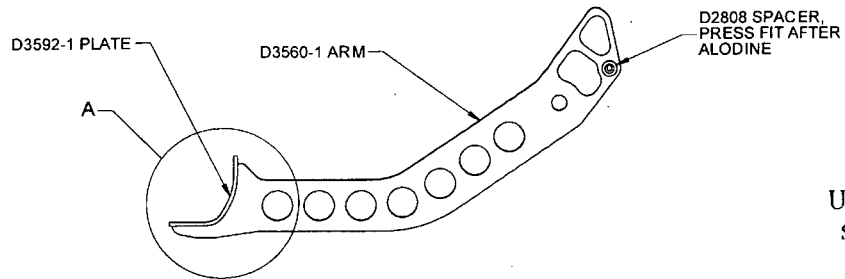
Measured by: <u> JL </u>	Audited by: <u> mf </u>	Prototype Approval: N/A
Date: 11-11-12	Date: 11/11/12	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	08.07.24	Dwg Rev updated	KJ/DD	<u> DD </u>

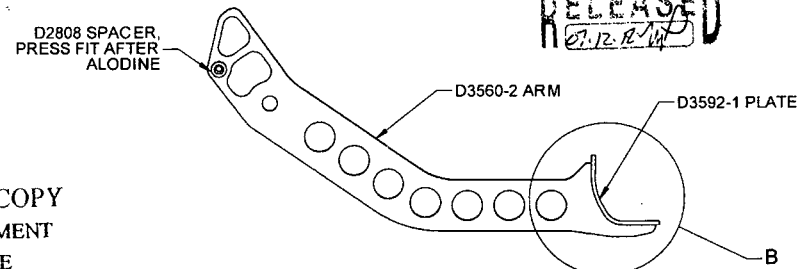
RELEASED
07.12.16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

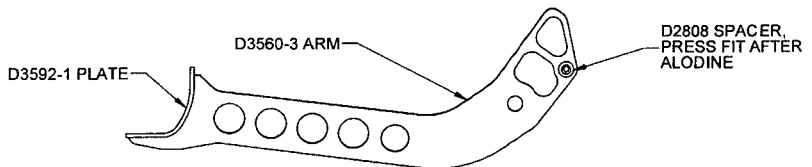
WORK ORDER
NO. 74803 M.C.J
11/10/06



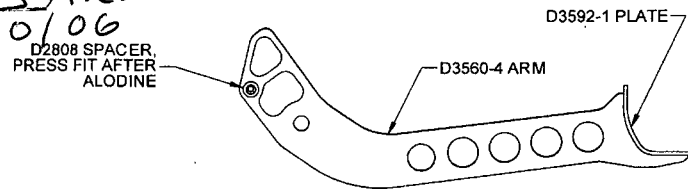
D3560-041 ARM WELDMENT



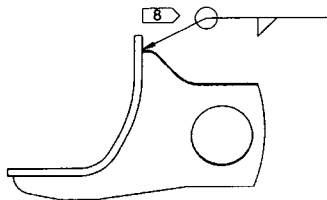
D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



**DETAIL A
SCALE 1 : 2**

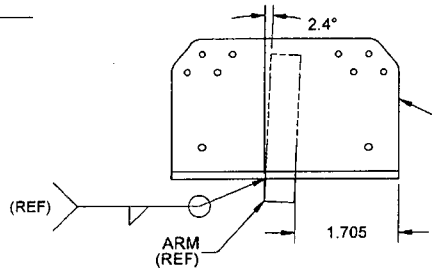
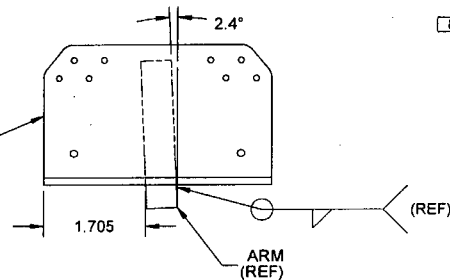
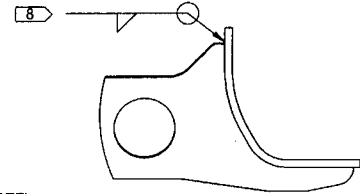


PLATE
(REF)



ARM
(REF)



**DETAIL B
SCALE 1 : 2**

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

- NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.23 lbs (TYP)
8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3560** REV. D
SHEET 1 OF 5

TITLE **ARM WELDMENT** SCALE 1:4

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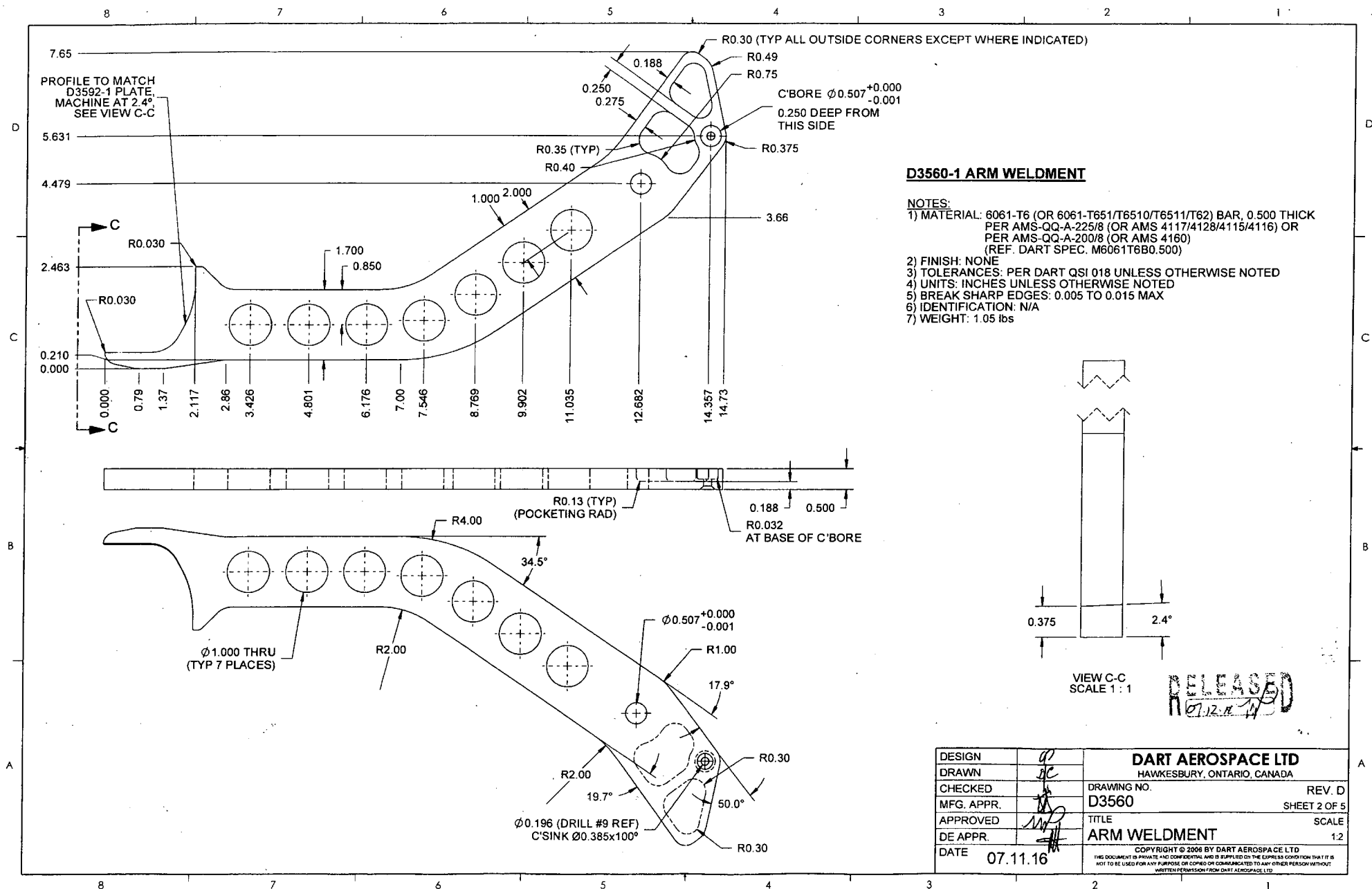
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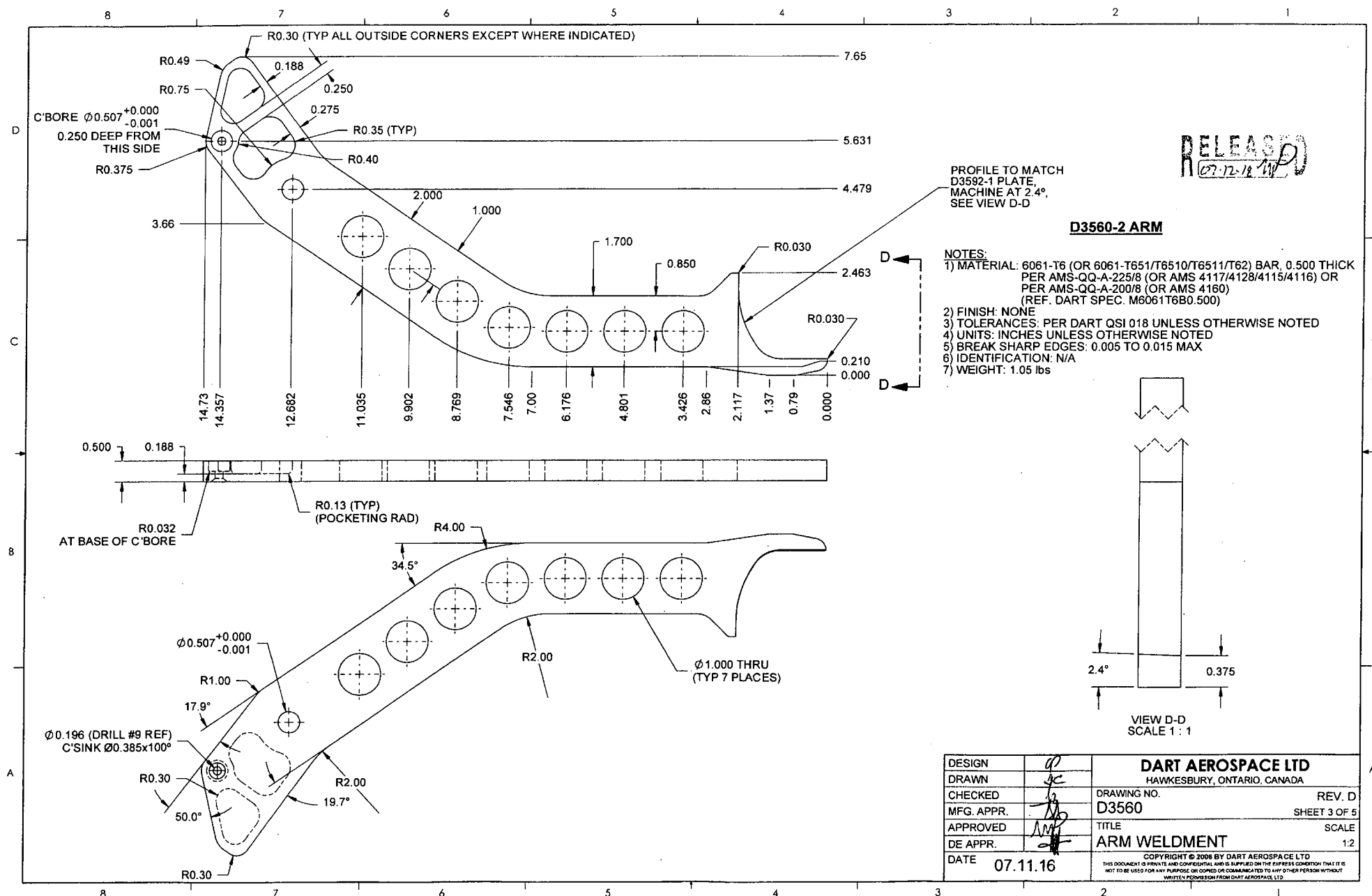
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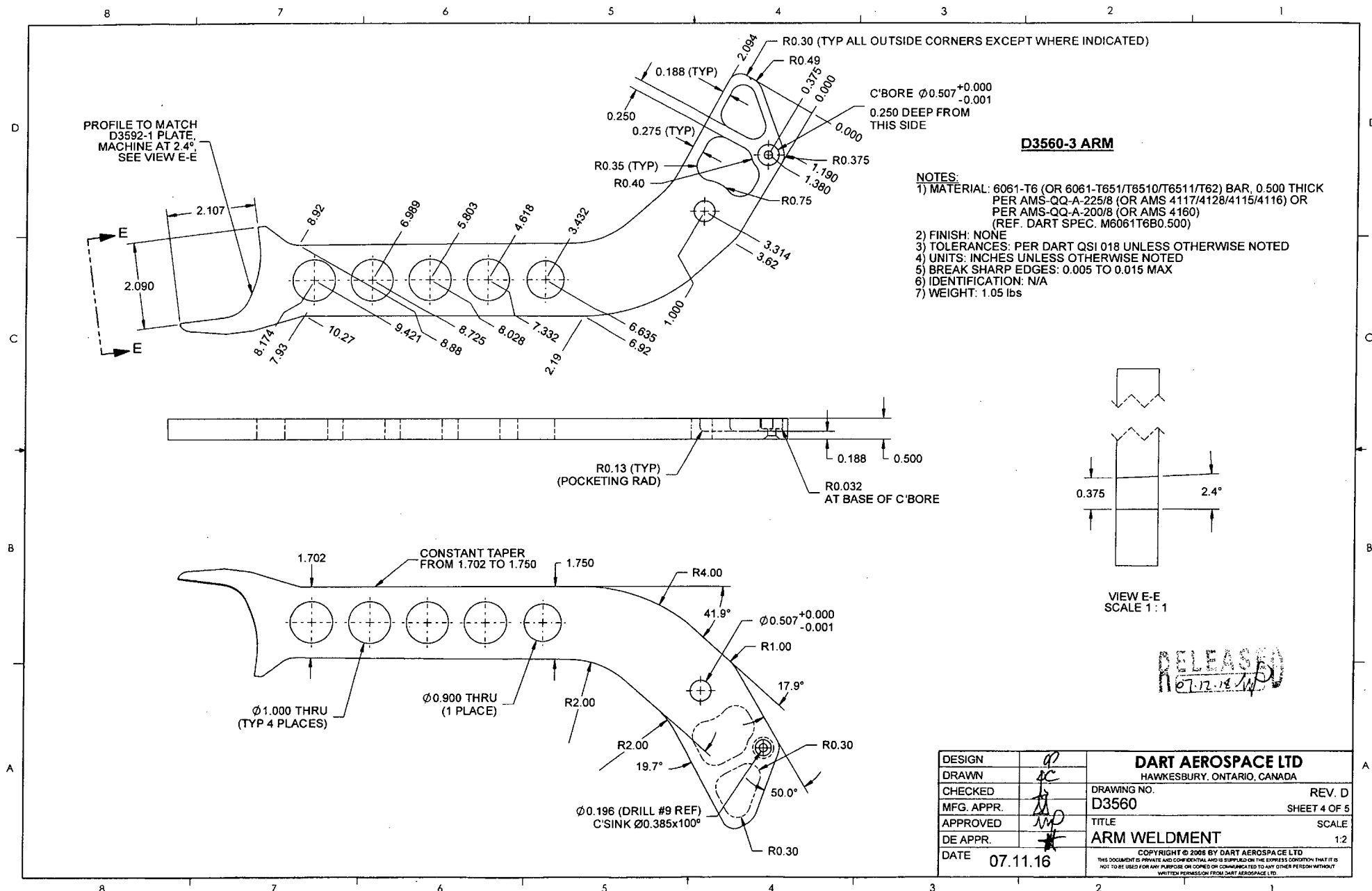
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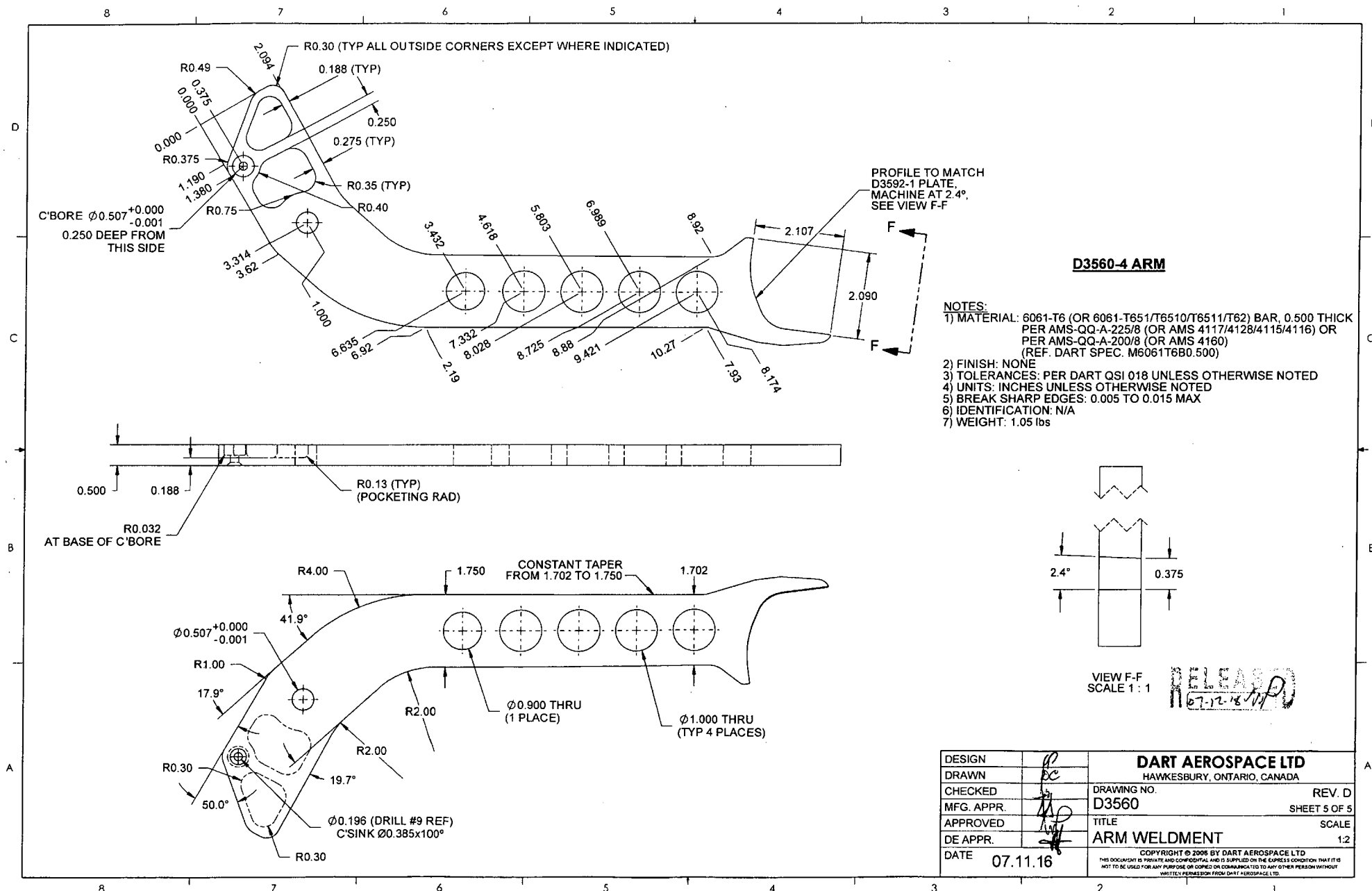
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